Dart Aerospace Ltd. Monday, 8/21/2006 2:12:25 PM Date: Kim Johnston **Process Sheet** User: : SADDLE SPACER **Drawing Name** : CU-DAR001 Dart Helicopters Services Customer Job Number : 28265 : 11063 **Fstimate Number** : NA : D2935 **Part Number** P.O. Number S.O. No. : NIA : D2935 REV B : 8/21/2006 **Drawing Number** This Issue : N/A : NC **Project Number** Prsht Rev. : NA MACHINED PARTS **Drawing Revision** Type First Issue : 27116 Material **Previous Run** : 9/6/2006 Qty: 40 Um: Each **Due Date** Written By Checked & Approved By Comment Est Rev:B Now 6061-T6 06-06-23 JLM **Additional Product** Job Number: Description: Machine Or Operation: Seq. #: 6061-T6 .080 Sheet M6061T6S080 1.0 0.0532 sf(s)/Unit Total: 2.1294 sf(s) Comment: Qtv.: Material: M6061-T6 0.080" Thick Batch M10178 FLOW WATER JET 2.0 WATER JET Comment: FLOW WATER JET 1-Cut as per Dwg D2935 Dwg Rev: B Prog Rev: \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_ SAD 06:08:23 ... 2-Deburr if necessary INSPECT PARTS AS THEY COME OFF MACHINE QC2 3.0 Comment: INSPECT PARTS AS THEY COME OFF MACHINE SAD SECOND CHECK 4.0 Comment: SECOND CHECK 40 HAND FINISHING RESOURCE #1 5.0 HAND FINISHING Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

06-09-06

## Dart Aerospace Ltd

W/O:		WORK ORDER C	HANGES				
DATE	STEP	Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR:		1	WORK OR	DER NON-CONFORMANC	E (NCR)	₹)				
1		Description of NC		Corrective Action Section B		Verification	Annroyal	Approval		
DATE	STEP	Section A	Initial Design Mgr	Action Description  Design Mgr	Sign & Date	Section C	Approval Design Mgr	Approval QC Inspector		
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Part No:	PAR #:	Fault Category: NO	CR:	Yes No DQA:	Date: 06/09/07
NOTE: Date & initial all entries				QA: N/C Closed:	Date:

Monday, 8/21/2006 2:12:25 PM Date: Kim Johnston User: **Process Sheet** Drawing Name: SADDLE SPACER Customer: CU-DAR001 Dart Helicopters Services Job Number: 28265 Part Number: D2935 Job Number: **Description:** Seq. #: **Machine Or Operation:** INSPECT POWDER COAT/CHEMICAL CONVERSION 6.0 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING RESOURCE # PACKAGING 1 7.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location:\_ 8.0 Comment: DOCUMENT CONTROL Inspection Level 21 Job Completion

## **Dart Aerospace Ltd**

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DART AEROSPACE LTD	Work Order:	28265
Description: Saddle Spacer	Part Number:	D2935
Inspection Dwg: D2935 Rev: B		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

Х	First Article		Prototype
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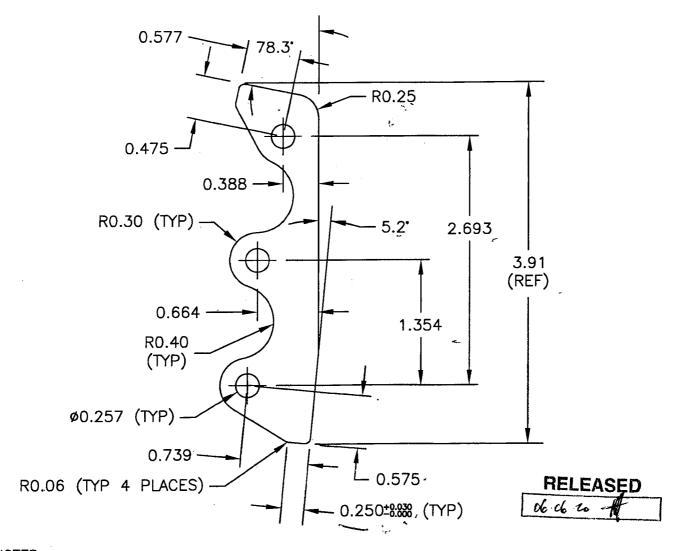
	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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	3.91	+/-0.030	3,916			Vertical Vern	
	1.354	+/-0.010	1,361	/		Vern	
] [	2.693	+/-0.010	2.695	~		Vern Vern R-6	
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Measured by: SAD	Audited by:	Prototype Approval:	N/A
Date: 06:08:23	Date: 06-08:73	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	06.06.05	New Issue	KJ/JLM	1
В	06.06.23	Dwg Rev. changed	KJ/JLM	
		<u> </u>		



DESIG	N [#	DRAWN BY	DART AEROSPACE US	A, INC.
CHEC		APPROVED	DRAWING NO.	REV. B
	PH		D2935	SHEET 1 OF 1
DATE		<u> </u>	TITLE	SCALE
06.0	5.29		SADDLE SPACER	1:1
Α		99.11.02	NEW ISSUE	
В		06.05.29	ADD 6061-T6 MATERIAL	



NOTES:

6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK 1) MATERIAL:

(REF DART SPEC M6061T6S.080)

SHOP COPY

5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK ENGINEERING

RETURN TO

(REF DART SPEC M5052H32S.080)

UNCONTROLLED COPY

2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED SUBJECT TO AMENDMENT

4) BREAK ALL SHARP EDGES 0.010 TO 0.020

WITHOUT NOTICE

WORK ORDER

5) ALL DIMENSIONS ARE IN INCHES

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